

Date: Thursday, 26/10/2006 2:38:12 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CC-DAR01 Dart Aerospace Ltd.	<b>Drawing Name</b> : DEO 9217
<b>Job Number</b> : 29187	
<b>Estimate Number</b> : 10804	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : DEO9217
<b>This Issue</b> : 26/10/2006 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : DEO 9217
<b>Prsht Rev.</b> : NG	<b>Project Number</b> : <i>N/A</i>
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : OVERHEAD	<b>Drawing Revision</b> : <i>N/A</i>
<b>Previous Run</b> : 00015	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 02/11/2006 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	
<b>Comment</b> : <i>[Signature]</i>	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
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**Comment:** COMPOSITE ASSEMBLY

MODIFY D350-602-013 PER DEO 9217

- USE 9OZ CLOTH B *101039*- USE RESIN EA9309NA B *M100921 / M102477*-USE MILLED FIBER B *M100859*

REMOVE PRIMER AND FOAM

FILL GAPS WITH MILLED FIBER \_\_\_\_\_

LAY 3 LAYERS OF 9 OZ FIBERGLASS

WITH HYSOL EA9309NA

USE 25LB BAGS FOR PRESSURE ON LAYERS OVER DOUBLER

LET CURE 24HRS

*ml 06/10/25*

2.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP*1806.10.26*

3.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
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**Comment:** COMPOSITE ASSEMBLY

SAND

*ml 06/10/26*

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP*Feb 10-01**1806.10.26*

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Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: DEO 9217

Job Number: 29187

Part Number: DEO9217

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING  
PRIME INSIDE OF POD

*06/11/01*

6.0 QC14 Inspect Spray Paint



Comment: Inspect Spray Paint

*06-11-02*

7.0 COMPOSITE ASSY COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY  
REPAIR BASE WITH  
HYSOL EA9309NA B *102477*  
MILLED FIBER B *M100859*  
LET CURE

*mlo06/10/30*

8.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING  
RE-PAINT BASE

*mlo06/11/02*

*(1)*

9.0 QC14 Inspect Spray Paint



Comment: Inspect Spray Paint

*06-11-03 (1)*

10.0 COMPOSITE ASSY COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY  
DO FINAL ASSEMBLY - GO TO  
W/O 28953 - D350-602-013

*See w/o# 28953 (step 23) mlo06/11/03*

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*06/11/03*

Job Completion



*U 06/11/03*

*P70*

See NCR →

STEP 5) Because, with the primer the look was bad the QC ask me to re-sand the area of doubler.

mloc/10/27

1) Re-Sand

2) Re-mixed Hypol 9309 NA M102477 as filler  
milled fiber M100859

mloc/10/27

3) Re-Sand

and go back to step 5. mloc/10/30

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Step 5a) Damage around Doubler patch req'd rework and fill gap between Doubler and outside edge  
1 - Re Sand and wipe clean with wash n wipe

2 - filled with Hypsol 934 N/A and milled fibre  
Hysol Batch M100775 ~~as~~  
milled fibre M100859 06/10/31

3 - Re Sand and go back to Step 5

~~as~~ 06/11/01

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DEO 9217 PAR #: N/A Fault Category: Supplier <sup>DELTA STICK</sup> NCR: Yes No DQA: DP Date: 06/11/03  
29187 QA: N/C Closed: DP Date: 06.11.03

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/01	1.0 3.0	During Priming, the Kevlar was noticed to be exposed all inside the Pod. Finish not good. Doubler fit was not good, had a .125 gap between the doubler, and the Pod, and can cause cracking in the Pod when riveting if the gap is not filled.	<u>AS</u>	Sand and rework area to seal off Kevlar <del>and</del> fill Air pockets, and gap between Pod, and doubler to ensure a solid assembly and no cracking of the pod. <del>Hysol 9309 B m102477</del> <u>AR</u> <del>milled fiber B m100859</del> <u>AR</u> Ensure that area is smooth and free of voids. <del>Hysol 934NA B m100775</del> <u>AR</u>	<u>TO</u> 06/11/01	<u>2</u>	<u>AS</u>	<u>06-10-30</u>
			<u>2</u>		<u>2</u> 06/11/01	<u>06/11/01</u>	<u>2</u>	<u>↓</u>

NOTE: Date & initial all entries

## ACTIVITY SUMMARY REPORT

# DART

**DART AEROSPACE LTD**  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7

Attendees:

w/o 28953.

DEO 9217

Report Type:

**Subject:**

**Venue:**

Date:

Sheet of

Item	Action / Description	Responsible	Due Date	Action / Date
7-	Because there a Knoch on the base (.250) I fill up with Hypol 9309 mill Fiber let cure			
8-	<del>Soft</del> Re-Paint Base.			
9-	Make the final assey			

# ACTIVITY SUMMARY REPORT



DART AEROSPACE LTD  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7

Attendees:

Report Type:

Subject:

Venue:

Date:

Sheet \_\_\_\_\_ of \_\_\_\_\_

N/O 28953

DEO 92/7

Item	Action / Description	Responsible	Due Date	Action / Date
	<p>HELI utility Pod</p> <p>9oz cloth 9'</p> <p>Batch # M101039</p> <p>Resin 9309 N/A</p> <p>Batch # m100921 / and m102477</p> <p>Milled Fiber m100859</p> <p>1) Remove Primer</p> <p>2) Remove Foam</p> <p>3) Fill gaps with milled Fiber</p> <p>4) lay down 3 layers of 9oz with bysal</p> <p>5) Can not make bagging so I use 2 yellow bags (25 lbs each) for press the doubler on layers let cure 24 hours.</p>			
	<p>6- Soft Sand and Re Prime inside</p>			<p>m1009/10/25</p> <p>1/2</p>